



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9348	REV. A SHEET 1 OF 1
DATE 06.08.23		TITLE SKIDTUBE WELD REPAIR	SCALE NTS
A	06.08.23	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND MAINTENANCE MANUAL SUPPLEMENTS MMS-D205-634 REV A OR B AND MMS-D204-635 REV A OR B
REF. CANADIAN STC: SH96-88
REF. FAA STC SR00563NY

FOR THE D205-634-011 OR D204-635-011 SKIDTUBE INSTALLATION, CRACKS IN THE WELDS AROUND THE HOLES OF THE D2580-041 OR D2590-041 SKIDTUBE ASSEMBLY SHOWN IN FIGURE 1 CAN BE REPAIRED AS FOLLOWS:

- 1) CLEAN AREA OF PAINT, ETC.
- 2) DRILL OUT THE D2579 SPACER USING A $\varnothing 0.508$ " DRILL.
- 3) CHAMFER 0.050" X 45° AROUND THE HOLE ON EACH SIDE OF THE SKIDTUBE. ENSURE THAT ALL REMAINING WELD AROUND THE HOLES IS REMOVED.
- 4) INSERT REPLACEMENT D2579 SPACER.
- 5) T.I.G. WELD CHAMFER PER MIL-STD-2219 / AMS-STD-2219 CLASS 'C' USING 4043 OR 5356 FILLER ROD ON EACH SIDE. DRILL THROUGH SPACER WITH $\varnothing 0.386$ " DRILL (DRILL W) TO REMOVE EXCESS WELD IF NECESSARY.
- 6) BLEND WELDS TO SAME PROFILE AS ORIGINAL PART.
- 7) IF USED FOR GROUND HANDLING, COUNTERBORE BOTH SIDES TO $\varnothing 0.437$ " X 1.00" DEEP AND DEBURR.
- 8) TOUCH UP FINISH IN ACCORDANCE WITH MMS-D205-634 REV A OR B OR MMS-D204-635 REV A OR B.

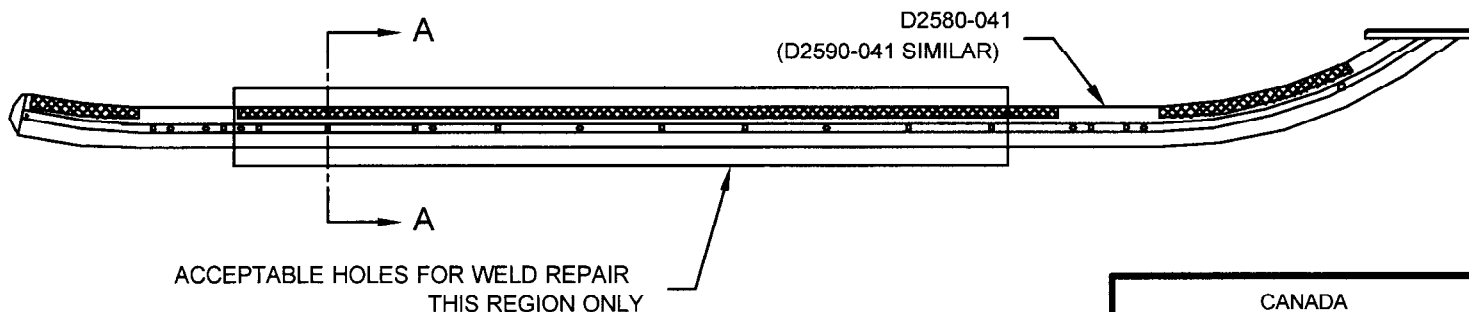
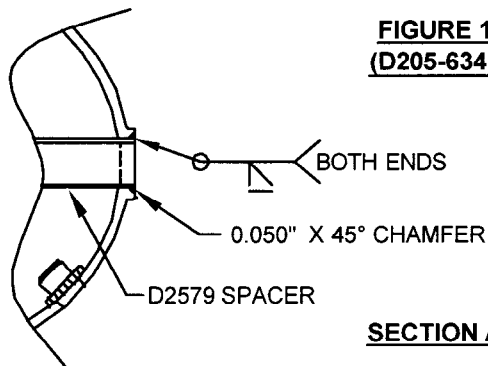


FIGURE 1. ACCEPTABLE AREA FOR REPAIR
(D205-634-011 SHOWN, D204-635-011 SIMILAR)



SECTION A-A

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.08.23
CERT. NO.: SH96-88
ISSUE NO.: 2

Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.